BASKET***

| NCR: ' | Yes / No | | | | WORK ORDER NON-C | CON | IFORN | NANCE / UPI | DATE | | | | | |
|---------------|------------|------------|------------|------------|--|-----|----------------------------|------------------------|------------------------|--------------|----------------------------|-------|------------------|--|
| | | | | | | | | | | QA Closed: | Dat | e: | | |
| Work Orde | er. | | | | DISPOSITION | ı | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| | | | | | Rework | | | Skid-tube Machining | Crosstube Small Fab | Dro | Water Jet d. Eng. Coor. | Engi | ineering Quality | |
| Part N | NO | | | | Scrap Use-as-is | | | noforming | Finishing | | re/Packaging | _ | Other | |
| NCR N | No | | | | Work Order Update | | | Large Fab | Composite | Rec/Stor | Supplier | | Other | |
| Root | | | | Descri | ption of work order update | I | nitial | Act | ion | Sign & | | | | |
| Cause | Date | Step | Qty | C | or Non-conformance | Ch | ief Eng | Descr | ription | Date | Verification | 1 Q | C Inspector | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | |
| Operator | | | | , | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | | | 1 | | | | | | | | | | | |
| Other | | | | | | | | | | | | - | | |
| Process | | | | | | | | | | | | [| | |
| Supplier | | | | | | | | | | | | | | |
| Training | | |]] | | | | | | | : | | | | |
| Unapproved | | 1 | | | THE RESIDENCE OF THE PARTY OF T | | | , | | | | | | |
| | | | | | F | AUL | T CATE | GORY | | | | | | |
| Landi | ng Gear | | | | General | _ | ı | | | 1 | , | · | | |
| | Bending | | | · L | Bend | | Grain | | | Ovalized | | _ | ure/Forced | |
| i | Centre N | ot Concer | ntric to C |)/S | BOM/Route | | Hardwa | re | | Over/Under | tolerance | Temp | erature/Cure | |
| | Cracks | | | | Broken/Damaged | Ш | Inspecti | on Incomplete | | Part Incorre | ct | Weld | | |
| | Crushed/ | Crimped. | | | Burrs | Ш | Instruct | ions Incomplete/l | Jnclear | Part Lost/Mi | ssing | Wron | g Stock Pulled | |
| | Cuffs | | | <u> </u> | Contamination | | Mainte | nance | | Part Moved | | | | |
| | Heat Trea | at | | | Countersink | | Mislabe | led | | Positioned V | Vrong | | | |
| | Inspectio | n Strip in | Tube | <u>.</u> | Cut Too Short | | Misread | i | | Power Loss/ | Surge | Other | - | |
| | Ripples ir | n Bend | | | Drill Holes | | Offset | | | | | | | |
| | Torque V | Vaves in E | extrusion | · _ | Drawing | | Out of 0 | Calibration | | | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

| Work Orde | | | | *950 | 16* | | | | Page 2 |
|--|---------|---|--------------------|--------------------------------------|----------------------------|---------------------------|-------|---------------|------------------------------|
| Item ID: Revision ID: Item Name: | D4020- | | | Accept | *N90004 | 40100* | Setup | Start Stop | *NS1* |
| Start Date: Required Date: Reference: | 1/14/13 | Start Qty: 2.00 Req'd Qty: 2.00 | *2* *2* | | Cust Item ID: Customer: | | | | |
| Approvals: | | s Plan: | Date: | Tooling: _ SPC (Y/N): | Date: | | Run | Start Stop | *NR1* *NR2* |
| Sequence ID/ Work Center II 130 *120* Packaging Packaging | D | Operation Description Identify as per dwg & Sto | ock Location: | Set Up/ Run Hours 0.00 0.00 | Tool ID To | ool# Plan Acc Code Qty | Qt | | Reject Insp. Number Stamp |
| 140 *140* QC Quality Control | | QC21- Final Inspection - Memo | Work Order Release | 0.00 | | | | 13/2 | 2/20/19 |
| | | | | | | | | 111 | |

| | | | | | | | | | | | DQA: | Date: | |
|---------------|----------|-----------|------------|---------------------------------------|-----|----------------------------|-----|--------------|------------------|------------|--------------|---------------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | VFORN | AANCE / UP | PDATE | | | |
| | | | | | | | | | | | QA Closed: | Date: | |
| Work Ord | or. | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Work Old | C1. | | | | | Rework | ו ר | | Skid-tube | Crosstube | 1 | Water Jet | Engineering |
| Part | No. | | | | | Scrap | 1 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| 1 | | | | | | Use-as-is | 1 | | noforming | Finishing | 4 | re/Packaging | Other |
| NCR | No. | | | | | Work Order Update | 1 | | Large Fab | Composite | 1 | Supplier | 1 🗆 |
| | | | | · · · · · · · · · · · · · · · · · · · | | | | | | | - | | |
| Root | | | | | | ption of work order update | 1 | Initial | | ction | Sign & | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Desc | cription | Date | Verification | QC Inspector |
| Doc/Data | <u> </u> | | | | | | | | | | | | |
| Equip/Tooling | L | | | | | | | | | | | | |
| Operator | L | | | | | | | | | | | | |
| Material | L | | | | | | 1 | | | | | | |
| Setup | L | | | | | | | | | | | | |
| Other | | | ļ | | | | | | | | | | |
| Process | | | ļ | | | | | | | | | | |
| Supplier | L | | | | | | | | - | | | | |
| Training | L | | | | | | | | | | | | |
| Unapproved | | | | | | | 1 | | | | <u> </u> | | |
| | | | | | | | AUL | T CATE | GORY | | | | |
| Landi | ng (| Sear | | | | General | | , | | م | _ | | |
| | | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | <u> </u> | Centre N | ot Concer | ntric to (| o/s | BOM/Route | | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | L | Inspecti | or: Incomplete | | Part Incorre | ct | Weld |
| 1 | | Crushed/ | Crimped. | | | Burrs | | Instructi | ions Incomplete, | /Unclear | Part Lost/M | issing | Wrong Stock Pulled |
| | L | Cuffs | | | | Contamination | | Mainte | nance | | Part Moved | | |
| | | Heat Trea | it | | | Countersink | | Mislabe | led | | Positioned \ | Wrong | _ |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | 1 | | Power Loss, | 'Surge | Other |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

January-02-13 11:51:28 AM

Work Order ID:

95016

Parent Item:

D4020-11

Parent Item Name:

End Mesh, Basket

Start Date: 1/14/13

Required Date: 1/14/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by;EC

IPP Rev:B as per dwg revA 10.03.15

36.5679

246.09 174.07

320

EC IPP Rev:C 10.06.14 remove cut out from dxf, will be made when install on

122884

123448

123855 124070

verified by:EC basket DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304EX0.75-16F Expanded Metal Flat SS | | Purchased | No | | ···· | 100 | sf | 1,226.0713 | 2.694 | 5.6715789 | *********** | | JMB- |
| | | | | Location | | Loc Qty | Lo | c Code | | | | | |
| | | | | WA007 | | 1226.071264 | | | | | | | |
| | | | | 117 | 197 | 102.9036 | | | | | | | |
| | | | | 120 | 917 | 50.88673 | | | | | | | |
| | | | | 121 | 521 | 0.00013372 | | | | | | | |
| | | • | | 122 | 080 | 63.0699 | | | | | | | |
| | | | | 122 | 315 | 11.245 | | | | | | | |
| | | | | 122 | 534 | 160 | | | | | | | |
| | | | | 122 | 604 | 61.238 | | | | | | | |

| NCR: | Yes | / No | | | | WORK ORDER NON-O | 100 | NFORN | /ANCE / UP | DATE | | | |
|---------------|---|------------|------------|----------|-------------|---------------------------------|----------------------------|--------------|--------------------|-----------|--------------|---------------|--------------------|
| | | | | | | | | | | | QA Closed: | Date | 2: |
| Work Ord | er. | | | | | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Work Ora | ··· | | | | | Rework | 1 | | Skid-tube | Crosstube | 1 | Water Jet | Engineering |
| Part I | No. | | | | | Scrap | 1 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| ! | | | | | | Use-as-is | | Therm | noforming | Finishing | Rec/Sto | re/Packaging | Other |
| NCR | ۷o. | | | | | Work Order Update |] | | Large Fab | Composite |] | Supplier | |
| Root | | | | | Descri | I ption of work order update | | nitial | Act | ion | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | _ | | | | | | | | | | | | |
| Operator | | | | | | | | | | | 1 | | |
| Material | | | | | | | 1 | | | | | | |
| Setup | | | | | | | | | ı | | | | |
| Other | | | | | | | | | 1 | | | | |
| Process | L | | | | | | | | 1 | | | | |
| Supplier | <u> </u> | | | | | | | | • | | | | |
| Training · | |] | | | ı | | | | | | | | |
| Unapproved | | | | | | | 1 | | | | | | |
| | | | | | | F | AUL | T CATE | 3C)RY | | | | |
| Landi | ng (| Gear | | | | General | _ | - | | | - | _ | |
| | | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | $ldsymbol{ldsymbol{ldsymbol{ldsymbol{ld}}}$ | Centre No | ot Concer | ntric to | o/s | BOM/Route | | Hardwa | re | | Over/Unde | r tolerance | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | Inspecti | on Incomplete | Ĺ | Part Incorre | ect | Weld |
| | | Crushed/ | Crimped. | | | Burrs | | Instruct | ioris Incomplete/L | Jnclear | Part Lost/M | lissing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | nance | | Part Moved | ł | |
| | | Heat Trea | it | | | Countersink | | Mislabe | led | | Positioned | Wrong _ | |
| | | Inspection | n Strip in | Tube | | Cut Too Short | | Misread | l | | Power Loss | /Surge | Other |
| | | Rinnles in | Rend | | | Drill Holes | | Offcet | | _ | _ | _ | |

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

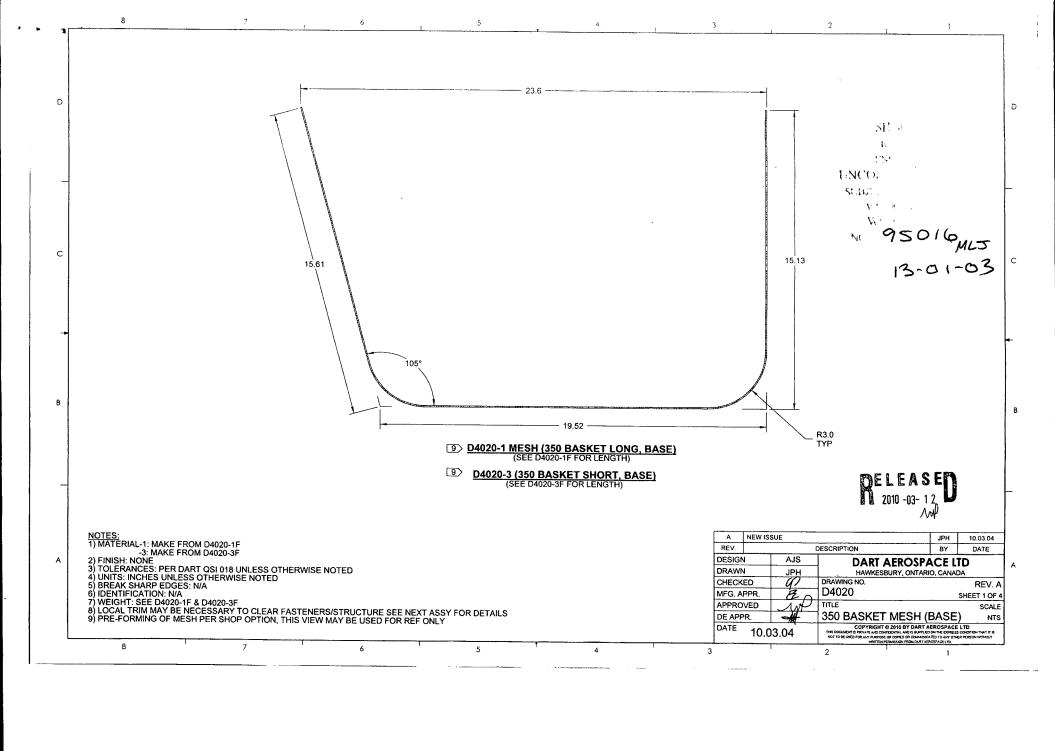
| DART AEROSPACE LTD | Work Order: | 95016 |
|-------------------------------|--------------|-------------|
| Description: End Mesh, Basket | Part Number: | D4020-11 |
| Inspection Dwg: D4020 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|-----------------|--------|-------------------------|----------------|
| 24.34 | +/-0.030 | 24.34" | _ | | + | Jhnos |
| 2.88 | +/-0.030 | 7.885 | 1 | | 7 | Jhnos Jhnos |
| 17.31 | +/-0.030 | 17.31 | * | | <u> </u> | |
| 15.50 | +/-0.030 | 15.50 | - | | 7 | |
| 20.18 | +/-0.030 | 20.18 | | | T | |
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| | | | 04 ¢ | | | |

| Measured by: Jm | Audited by: | Preliminary Approval: | N/A |
|-----------------|-------------|-----------------------|-----|
| Date: 13-2-6 | Date: 13.26 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| Α | 10.04.01 | New Issue | KJ (A | D |
| В | 10.08.03 | Dimensions updated | KJ det | 24 |



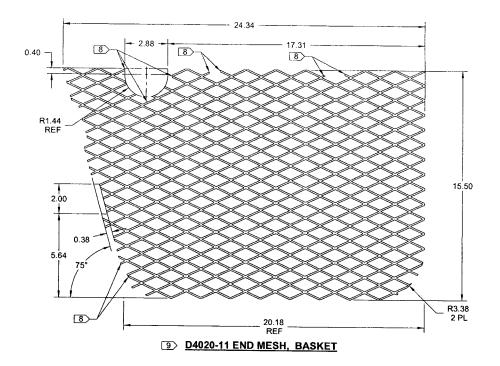
95016 D4020-5: 95.25 D4020-7: 56.00 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 9 <u>D4020-5 MESH (350 BASKET LONG, LID)</u> (LOCAL SECTION MESH SHOWN FOR CLARITY) 9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 ibs APPROX
-7: 4.49 ibs APPROX DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF 4 ## 1-0: 0.00 IDS APPROX

| 1-3: 4.49 Ibs APPROX

| LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

| TOLERANCE ON XX.XX DIMENSIONS ± 0.06. APPROVED TITLE 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
PRESOCUMENT IS PRIVATE AND COMPEDITIES NOT SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO RE USED FOR HAVE PURPOSE ON COMPEDITIES AND THAT MORE PRIVATED HYDROGODY THAT AND AREA PRIVATED HYDROGODY THAT AND AREA PRIVATED HYDROGODY THAT AND AREA PRIVATED. DATE 10.03.04

95016



D

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1 22 INE

7) WEIGHT: 1.22 lbs

7) WEIGHT 1.22 103 \pm 0.00 S NUCCELLAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS \pm 0.06.

DESIGN AJ\$ **DART AEROSPACE LTD** DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4020 CHECKED REV. A MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS DATE COPYRIGHT @ 2010 BY DART AEROSPACE LTD
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